



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3238-13

Job Sheet 177041



Part No: D3238-13

Job Qty: 6 ea

Part Name: Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/4/18

Job Tracking No:

Due Date: 5/24/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV C IPP Rev:A New Issue 06-10-20 EC IPP Rev:B Now on Waterjet 07-01-26 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	5/24/18	5/24/18	0.00	0.00	Start Up Waterjet		SC 5/26/18
100	Waterjet	6 pcs	5/24/18	5/24/18	0.00	0.26	Waterjet1		SC 5/26/18
110	QC	6 pcs	5/24/18	5/24/18	0.00	0.00	QC2 Waterjet-1		SC 5/26/18
120	QC	6 pcs	5/24/18	5/24/18	0.00	0.00	QC8-2		SC 5/26/18
130	HandFinish	6 pcs	5/24/18	5/24/18	0.00	0.12	HandFinish1		SA 5/26/18
140	QC	6 pcs	5/24/18	5/24/18	0.00	0.00	QC3		SC 5/26/18
150	Packaging	6 pcs	5/24/18	5/24/18	0.00	0.00	Packaging3	ST 027 88	JUN 19 2018
160	QC21-SA	6 Ea	5/24/18	5/24/18	0.00	0.00	QC21		DAS 5/26/18

Part Op 100 - 1-Cut as per Dwg D3238 Dwg Rev: C Prog Rev: C 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Chemical Conversion Coat per QSI005 4.1

140 - QC3- Inspect Part Finish

150 - Identify as per dwg & Stock Location:

160 - QC21- Final Inspection - Work Order Release

m6061+65.020 CY MAY 23 2018

Job BOM

Job BOM records could not be found.

M50521/325.020 0.014 each

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 5/4/18 12:42 PM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S079634



Part: D3238-13

Job No: 177041

Serial No/Batch: S079634

Revision:

Inspector:

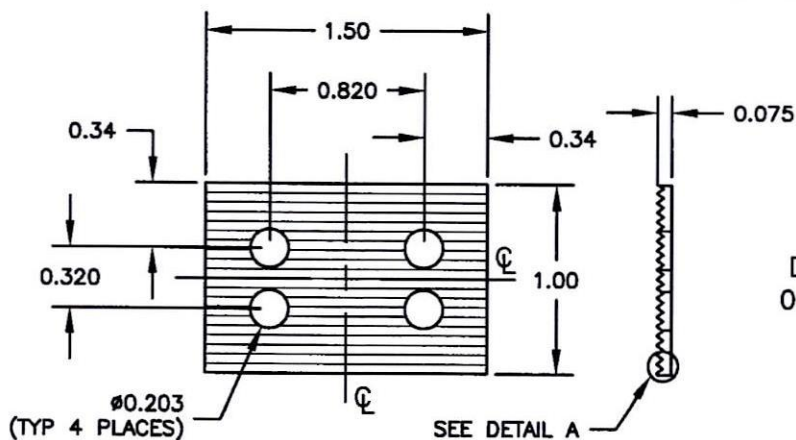
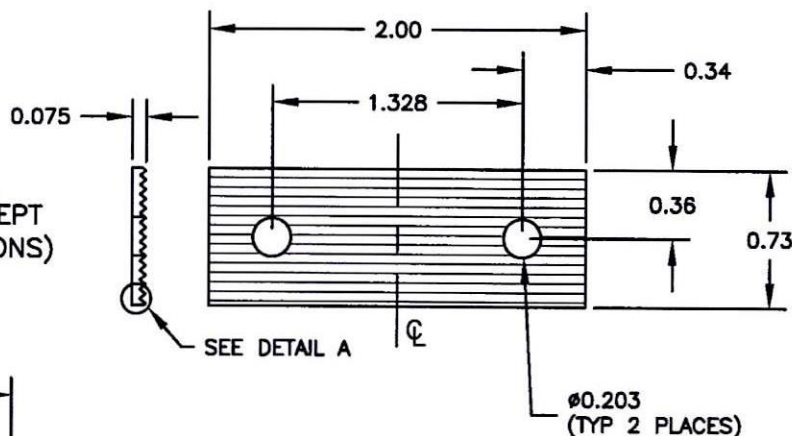
Exp Date:

Instructions:

Date: 06/11/18

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED07.02.20 **#****D3238-1 PLATE (SHOWN)**D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)**D3238-3 PLATE (SHOWN)**D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)**NOTES:**

1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:

ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)

-11/-13/-15/-31/-33/-35 PLATE:

ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
ORALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) SEE SHEET 3 FOR DETAIL A

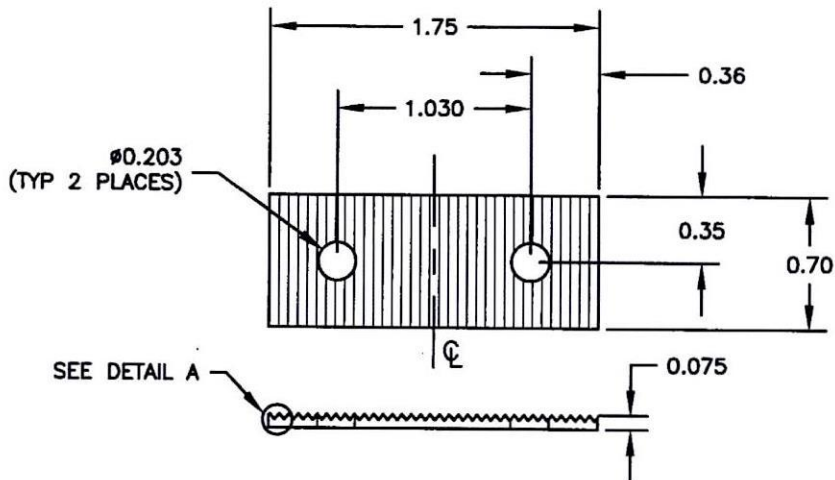
7) PARTS ARE SYMMETRIC ABOUT ϕ

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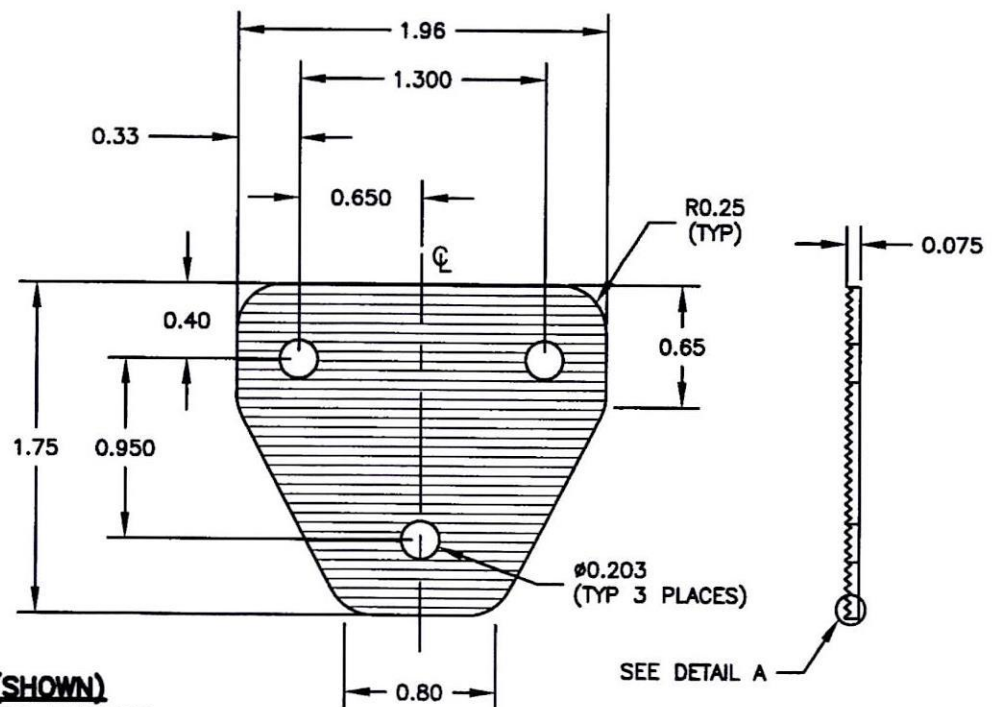
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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1

**RELEASED**

07.02.20

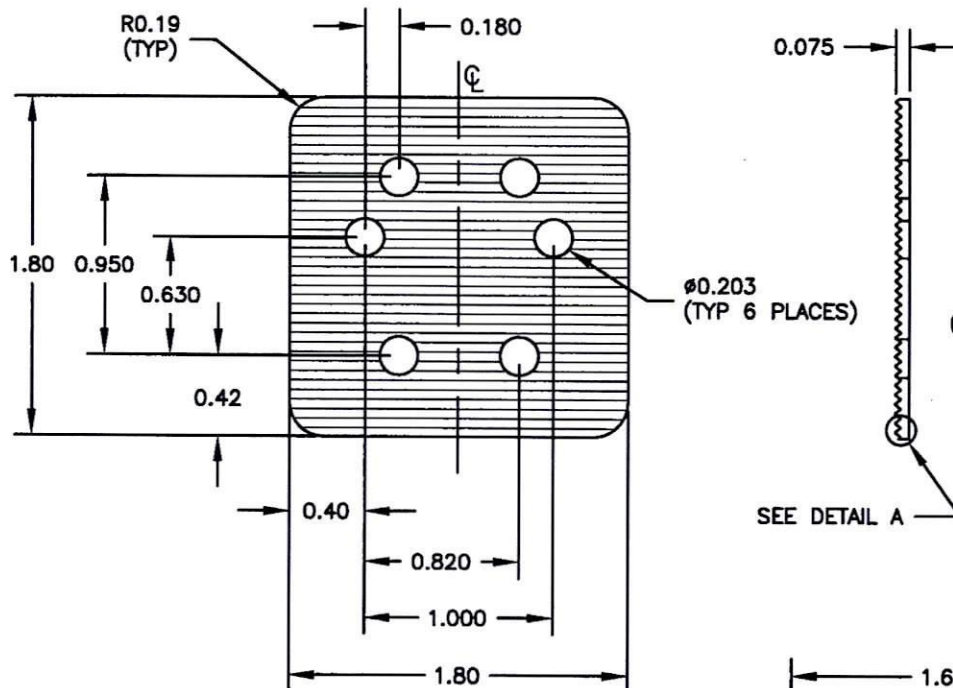
D3238-5 PLATE (SHOWN)D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)**D3238-21 PLATE (SHOWN)**D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1

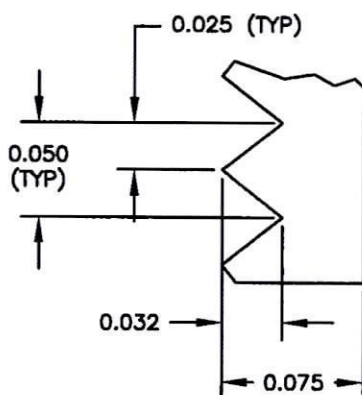


RELEASED

07.02.20 #

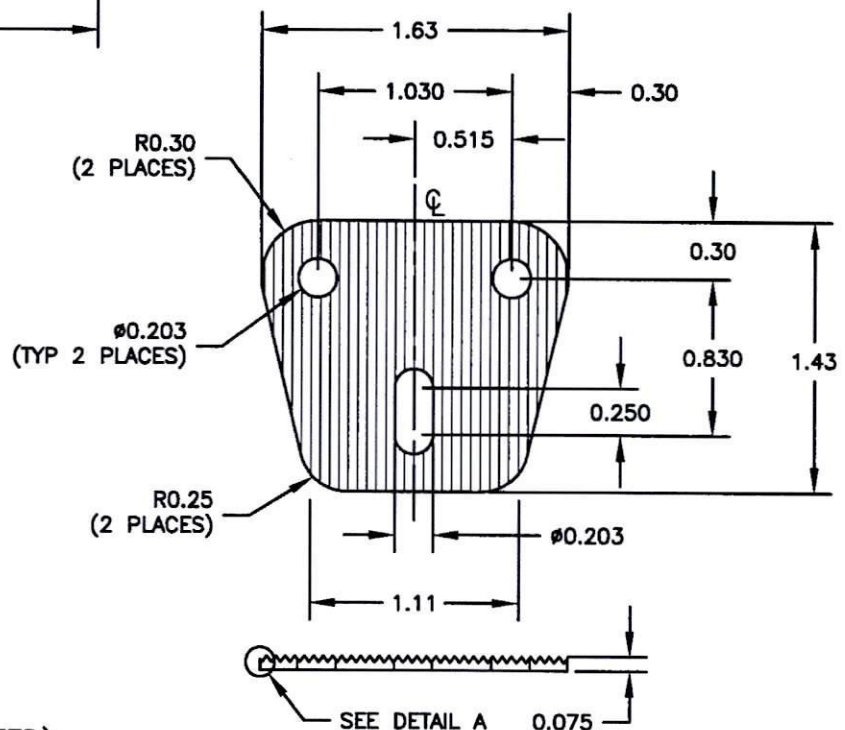
D3238-23 PLATE (SHOWN)
 D3238-33 PLATE (SAME, EXCEPT
 0.020 THICK AND NO SERRATIONS)

SEE DETAIL A



DETAIL A

RIDGE DETAIL (VIEW MAY BE ROTATED)
 SCALE 10:1



D3238-25 PLATE (SHOWN)
 D3238-35 PLATE (SAME, EXCEPT
 0.020 THICK AND NO SERRATIONS)

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